

Date: Wednesday, 6/28/2006 4:18:28 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 27756A	Part Number	: D2280
Estimate Number	: 10352	Drawing Number	: D2280 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 6/28/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Type	: SMALL /MED FAB
First Issue	: N/A		
Previous Run	: 25395A	Material	: N/A
Written By	<i>See Comment Below</i>		
Checked & Approved By	<i>JF 06 06 07</i>		
Comment	: Est Rev:A New Issue 05-11-07 JLM		
Qty: <i>41</i> Um: Each			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0250X01000	6061-T6 Bar .25" x 1.0"	
		Comment: Qty.: 0.2975 f(s)/Unit Total : 11.8986 f(s) Material: 6061-T6 (QQ-A-250/8) 0.25" Thick (M6061T6B0.250x1:000)Identify as D2280 Batch: <i>M18237</i>	
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut blank: (3.400") +/-0.020"	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2280 and Dwg D2280	
		2-Deburr Then Tumble	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/07/05

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06-07-04

41

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

41

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 36

H.M 06-07-04

41

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/05 41

Job Completion



in 06-07-05

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

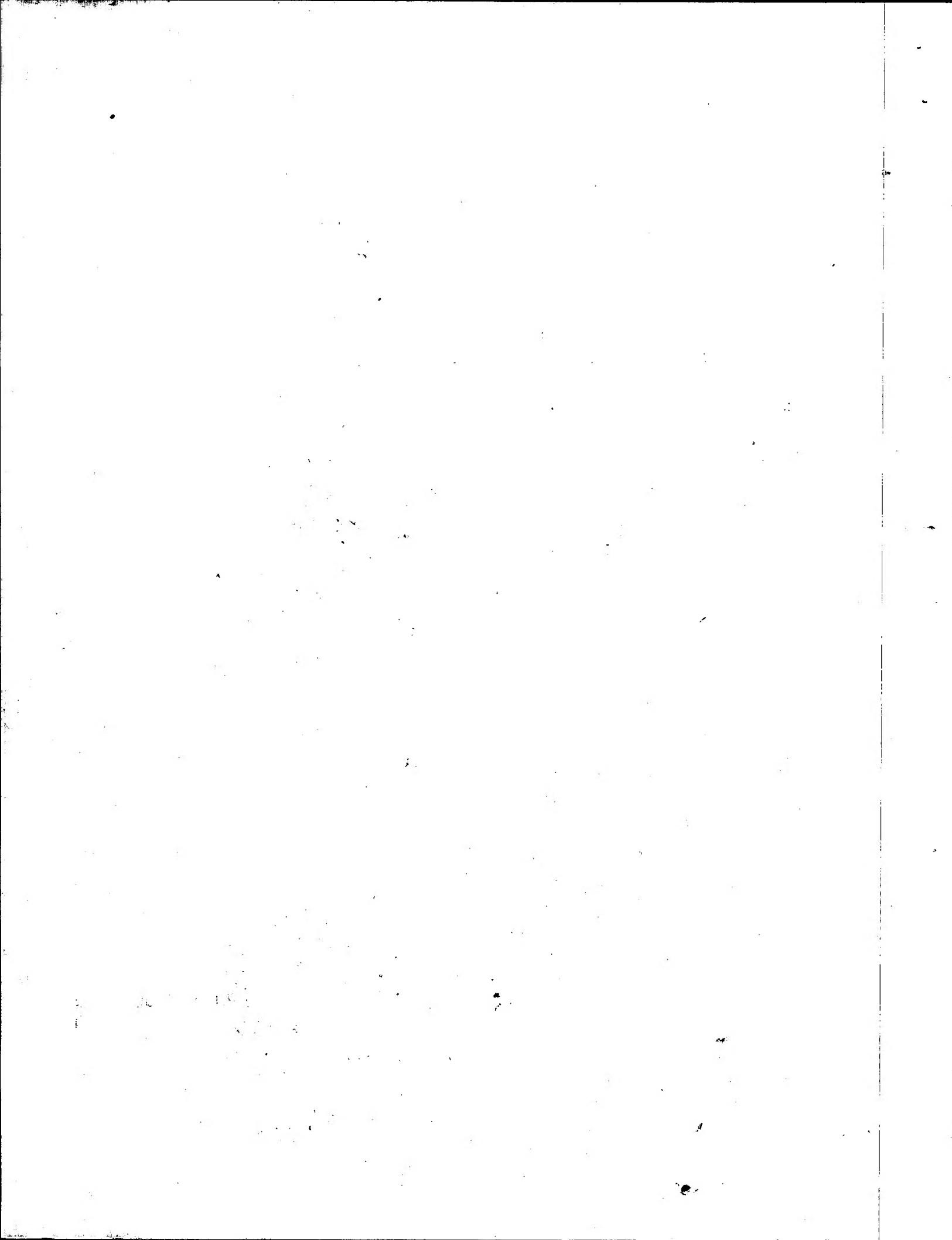
DART AEROSPACE LTD	Work Order:	27756A.
Description: Spacer	Part Number:	D2280
Inspection Dwg: D2280	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

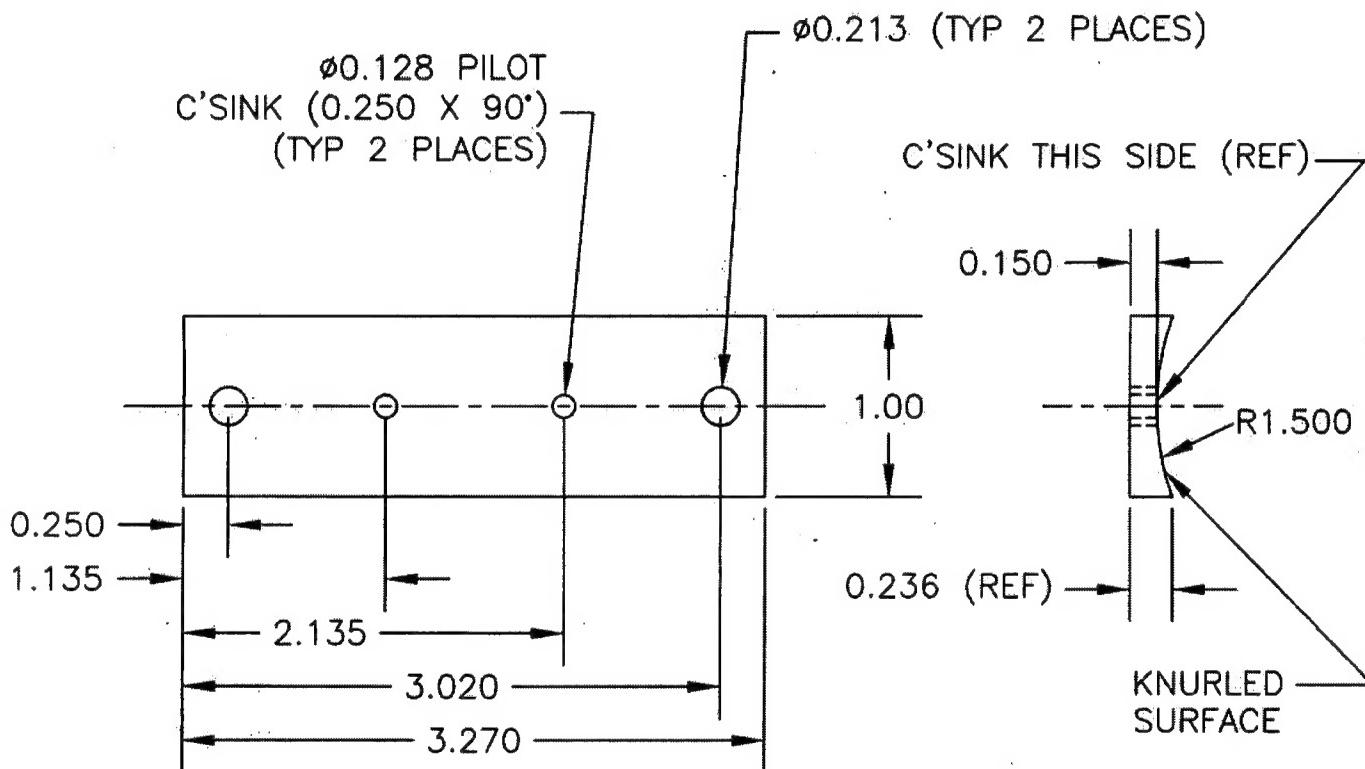
Measured by:	J.F.	Audited by:	J.G.	Prototype Approval:	N/A
Date:	06/07/01	Date:	06/07/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	
B	06.03.08	Dwg Rev changed	KJ/JLM	<i>[Signature]</i>



DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2280	REV. D SHEET 1 OF 1
DATE 05.11.14		TITLE SPACER	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20	
C	98.09.29	0.188 DIA HOLE CHANGED TO 0.213	
D	05.11.14	ADD FINISHING NOTE	

RELEASED
05.11.28 *[Signature]*D2280 SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250X1.000 INCHES NO. 1000
SUBJECT TO AMENDMENT
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 WITHOUT NOTICE
- 3) ALL DIMENSIONS ARE IN INCHES WORK ORDER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED NO. 27756A

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RETURN TO

ENGINEERING

